



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2891-1

Job Sheet 205282



Part No: D2891-1

Job Qty: 40 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/7/20

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2891 REV C IPP C 08.03.19 Re-format EC verified:DD/IPP Rev:E 11.08.04 as per dwg rev.B DD
verf:EC/IPP Rev.F 19.12.02 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	40 pcs	2/14/20		1.00	32.79	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	40 pcs	2/14/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S252856



Part: D2891-1

Job No: 205282

Serial No/Batch: S252856

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/03/20

					QC 2 - 8	
					QC 2 - 66	DAS
					QC 2 - 64	mm 64 2000/02/03
					QC 2 - 65	9-89
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	7x 20/02/03
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
QC 8 - 76						
QC 8 - 61						
130 Crosstubes - 2 - B4B	40 pcs	2/14/20	0.00	1.89	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	DAS
					Crosstubes - 4 - B4B	41 FEB 0 9 2020
140 QC 3	40 pcs	2/14/20	0.00	0.00	QC 3 - 10	3-89
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	DAS
					QC 3 - 40	FEB 0 6 2020 40
					QC 3 - 19	8-89
					Plex 1/7/20 8:51 AM Dart.lajeunesse.marie	

				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170	Packaging 3-1 - Stock - B4B 40 pcs	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 74 9-89
				Packaging 3 - 5 - B4B	LG050 FEB 07 2020
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA 40 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 FEB 07 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 520699 exp 8/21
 140 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____ LOCATION : LG052
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	20 pcs (.5 ea)	100-HAAS 4 Axis	
				5244560 = 8 5251416 = 3
				5224787 = 8
				5200832 = 2
				5167691 = 2

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK076	20	20	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

Plex 1/7/20 8:51 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	205282
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.191
AB	0.240	0.260		.252	.252	.253	.253	.255
AC	0.115	0.150		.128	.128	.127	.127	.126
AD	0.040	0.060		.052	.051	.051	.051	.048
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250
AG	0.290	0.310		.300	.300	.295	.297	.300
AH	0.115	0.150		.137	.138	.137	.137	.137
AI	0.454	0.474		.460	.461	.461	.461	.461
AJ	2.779	2.789		2.779	2.779	2.779	2.778	2.781
AK	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	.250
AL	1.002	1.042		1.037	1.036	1.036	1.035	1.031
AM	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063
AN	0.257	0.262		.261	.261	.260	.260	.261
AO	1.663	1.683		1.671	1.673	1.670	1.671	1.672
AP	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063
AQ	0.022	0.042		R.032 OK	R.032 OK	R.032 OK	R.032 OK	R.032
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>MM</i> ⁶⁴ ₉₋₈₉ <i>mm</i>	Date: 2020/01/29
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 205262
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	72	68	94	108
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.249	.247	.243	.246	.251
AC	0.115	0.150		.124	.124	.124	.124	.125
AD	0.040	0.060		.049	.050	.043	.049	.047
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.136	.136	.137	.139	.137
AI	0.454	0.474		.460	.460	.461	.462	.461
AJ	2.779	2.789		2.784	2.784	2.788	2.788	2.789
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.038	1.035	1.038	1.038	1.031
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.261	.261	.261	.261	.261
AO	1.663	1.683		1.672	1.675	1.674	1.676	1.677
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JMM	Date: 20/01/30
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	205282
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 1	1 2	1 3	1 4	1 5
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.1900
AB	0.240	0.260		.247	.248	.247	.255	.255
AC	0.115	0.150		.127	.126	.125	.125	.125
AD	0.040	0.060		.048	.040	.040	.046	.043
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.138	.138	.139	.139
AI	0.454	0.474		.463	.460	.460	.460	.460
AJ	2.779	2.789		2.789	2.789	2.789	2.789	2.789
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.031	1.034	1.032	1.031	1.027
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.261	.261	.261	.261	.261
AO	1.663	1.683		1.674	1.674	1.676	1.673	1.676
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JML	Date: 20/01/30
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	205282
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 16	2 17	3 18	4 19	5 20
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.247	.246	.245	.247	.250
AC	0.115	0.150		.124	.124	.124	.126	.129
AD	0.040	0.060		.045	.043	.041	.042	.041
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.139	.138	.138	.139
AI	0.454	0.474		.460	.460	.460	.460	.460
AJ	2.779	2.789		2.789	2.789	2.789	2.789	2.789
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.034	1.030	1.033	1.035	1.035
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.261	.261	.261	.261	.261
AO	1.663	1.683		1.670	1.677	1.673	1.673	1.673
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by:	mm L	Date:	20/01/31
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 205282
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	25
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.252	.250	.249	.249	.251
AC	0.115	0.150		.125	.124	.125	.124	.125
AD	0.040	0.060		.047	.049	.044	.049	.047
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.137	.137	.138	.139	.139
AI	0.454	0.474		.460	.463	.463	.462	.461
AJ	2.779	2.789		2.789	2.782	2.784	2.783	2.782
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.041	1.040	1.040	1.037	1.038
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.261	.261	.261	.261	.261
AO	1.663	1.683		1.673	1.674	1.673	1.675	1.674
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: JML / m.m.	DAS 64 9-89	Date: 20/01/31
Audited by:		Date:
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 205282
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	126	227	128	229	305
HAAS Section								
AA	0.188	0.193		.190 Ø	.190 Ø	.190 Ø	.190 Ø	.190 Ø
AB	0.240	0.260		.249	.249	.249	.249	.249
AC	0.115	0.150		.126	.125	.127	.126	.126
AD	0.040	0.060		.048	.047	.047	.048	.049
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AG	0.290	0.310		.305	.305	.305	.300	.300
AH	0.115	0.150		.128	.128	.137	.138	.138
AI	0.454	0.474		.463	.463	.463	.463	.463
AJ	2.779	2.789		2.782	2.781	2.781	2.782	2.782
AK	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AL	1.002	1.042		1.038	1.039	1.039	1.037	1.038
AM	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AN	0.257	0.262		.260 Ø	.260 Ø	.260 Ø	.260 Ø	.260 Ø
AO	1.663	1.683		1.674	1.674	1.675	1.674	1.674
AP	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AQ	0.022	0.042		R.032 OK	R.032 OK	R.032 OK	R.032 OK	R.032 OK
AR								
AS								
AT								
Accept/Reject								

Measured by: MM. 64	Date: 2020/02/01
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	205282
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	31	32	33	34	35
HAAS Section								
AA	0.188	0.193		.190 p	.190 p	.190 p	.190 p	.190 p
AB	0.240	0.260		.249	.248	.248	.248	.249
AC	0.115	0.150		.125	.125	.125	.124	.125
AD	0.040	0.060		.049	.050	.050	.050	.050
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AG	0.290	0.310		.305	.305	.305	.305	.305
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.462	.461	.461	.460	.461
AJ	2.779	2.789		2.782	2.782	2.783	2.782	2.781
AK	0.240	0.260		R.250 ok	R.250 ok	R.250 ok	R.250 ok	R.250 ok
AL	1.002	1.042		1.037	1.036	1.036	1.038	1.036
AM	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AN	0.257	0.262		.260 p	.260 p	.260 p	.260 p	.260 p
AO	1.663	1.683		1.674	1.675	1.675	1.675	1.674
AP	0.053	0.073		R.063 ok	R.063 ok	R.063 ok	R.063 ok	R.063 ok
AQ	0.022	0.042		R.032 ok	R.032 ok	R.032 ok	R.032 ok	R.032 ok
AR								
AS								
AT								
Accept/Reject								

Measured by: M.M. 64 9-89 Date: 2020/02/01

Audited by: Date:

Preliminary Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 205282
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	136	237	338	439	540
HAAS Section								
AA	0.188	0.193		.190 Ø	.190 Ø	.190 Ø	.190 Ø	.190 Ø
AB	0.240	0.260		.253	.255	.253	.254	.252
AC	0.115	0.150		.125	.126	.127	.126	.127
AD	0.040	0.060		.049	.050	.050	.051	.051
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AG	0.290	0.310		.310	.310	.308	.305	.308
AH	0.115	0.150		.137	.136	.137	.134	.135
AI	0.454	0.474		.465	.466	.465	.466	.466
AJ	2.779	2.789		2.781	2.782	2.781	2.783	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AL	1.002	1.042		1.037	1.036	1.036	1.038	1.038
AM	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AN	0.257	0.262		.260 Ø	.260 Ø	.260 Ø	.260 Ø	.260 Ø
AO	1.663	1.683		1.677	1.676	1.678	1.678	1.678
AP	0.053	0.073		R.063	R.063	R.063	R.063	R.063
AQ	0.022	0.042		R.032	R.032	R.032	R.032	R.032
AR								
AS								
AT								
Accept/Reject								

Measured by: M.M.	Date: 2020/02/02
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	205282
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B <	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	4 1	4 2	4 3	4 4	4 5
HAAS Section								
AA	0.188	0.193		.190 Ø	.190 Ø	.190 Ø	.190 Ø	.190 Ø
AB	0.240	0.260		.251	.251	.252	.252	.253
AC	0.115	0.150		.126	.126	.127	.126	.128
AD	0.040	0.060		.051	.050	.049	.049	.050
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AG	0.290	0.310		.301	.302	.305	.306	.302
AH	0.115	0.150		.135	.136	.136	.137	.137
AI	0.454	0.474		.460	.461	.464	.462	.461
AJ	2.779	2.789		2.780	2.779	2.779	2.779	2.781
AK	0.240	0.260		R.250 OK	R.250 OK	R.250 OK	R.250 OK	R.250 OK
AL	1.002	1.042		1.037	1.038	1.034	1.038	1.037
AM	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AN	0.257	0.262		.260 Ø	.260 Ø	.260 Ø	.260 Ø	.260 Ø
AO	1.663	1.683		1.677	1.676	1.676	1.674	1.675
AP	0.053	0.073		R.063 OK	R.063 OK	R.063 OK	R.063 OK	R.063 OK
AQ	0.022	0.042		R.032 OK	R.032 OK	R.032 OK	R.032 OK	R.032 OK
AR								
AS								
AT								
Accept/Reject								

Measured by:	mm	DAS 64 9-89	Date:	2020/02/03
Audited by:			Date:	
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	